



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C3-4-4
Job Sheet 186674



LOAD

Part No: C3-4-4

Job Qty: 6 ea

Part Name: Load Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-4-4A/C3-4-4KA Rev 10 IPP Rev A 18.03.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Waterjet2		OK 11/11/19
100	Waterjet - Flow - B4B	6 pcs	11/30/18	11/30/18	0.08	1.00	Waterjet 2 OMAX		OK 11/11/19
120	CNC Vertical Machining	6 pcs	11/30/18	11/30/18	2.00	3.00	NV5000-1		Not Require PL
130	QC	6 pcs	11/30/18	11/30/18	0.00	0.00	QC2 Machining-5		Not Require PL
140	QC	6 pcs	11/30/18	11/30/18	0.00	0.00	QC8 Machining-5		Not Require PL
150	Outsource	6 pcs	11/30/18	11/30/18			ARR002-VU		OK 11/11/19
160	Packaging	6 pcs	11/30/18	11/30/18	0.00	0.00	Packaging2		JAN 17 2019
170	QC	6 pcs	11/30/18	11/30/18	0.00	0.00	QC6		FEB 8 2019
180	Packaging	6 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-2		21 28 9-89
190	QC21-SA	6 Ea	11/30/18	11/30/18	0.00	0.00	QC21		MAR 07 2019

Part Op 100 - 1-Cut C3-4-4 blank (CANAM FOLDER) Dwg Rev: 10 Prog Rev: 10 2-Deburr if necessary
Descriptions: 120 - 1-Machine as per folio FC286 FOLIO REV: DWG REV: 2-Deburr ***MACHINE
ENGRAVE AS PER DWG***
150 - 1--Issue P/O to Metcore ; P/O RC 53-56 2-Bead blast 3- Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-1.000X10.000	AISI 4140 Steel Sheet/Plate	1.5600 ft (.26 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-S-1.000X10.000	2	3	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☒</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☒																							
Date : <u>19-03-06</u>		Step #: <u>150</u>		QTY Effective : <u>①</u>		MRB (QSI042) Approval																			
Description Work Order Deviation				Disposition																					
dimension 25 .791 $\pm .005$ is at .800" See supplier tag for scrap.				Scrap destroy.																					
				Completed By <u>PD 19-03-06</u>																					
				Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval <u>PD 19-03-06</u>																					
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								



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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S134438



Part: C3-4-4

Job No: 186674

Serial No/Batch: S134438

Revision: 10

Inspector:

Exp Date:

Instructions:

Date: 12/04/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042034**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO042034
PO Date: 12/12/18
Due Date: 1/14/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick
Phone:
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Ship To:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	186674	C3-4-4			Load Beam 1--Issue P/O to Metcore ; P/O RC 53-56 2-Bead blast 3- Certificate of Conformity is required	Firmed	-	1/14/19	6 pcs	0 pcs	6 pcs	\$0.01/pcs	\$0.06
Line Item Note BATCH # S134438												Grand Total: \$0.06	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/12/18 11:05 AM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 385

Date: 1/15/2019
PO Ref: 042034
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty

5

1

Item

LOAD BEAM (S134438)

LOAD BEAM (S134438) SCRAP

Part No.

C3-4-4

C3-4-4

Received by:

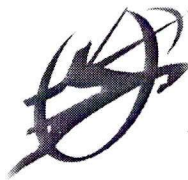
Packaged by:

Checked by:

J.M.-L

WJ

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 042034 Dated: 1/15/2019

Our Order / Job No: 042034-1AWT Order Qty: 5 OF 6

Part Name: LOAD BEAM

Part Number C3-4-4

Lot Size: S134438 Ship Date: 1/15/19

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: C3-4-4 Rev: 10

Material Size and Type: 4140 STEEL

Material Specifications: STEEL: ASTM A108. ASTM A29

Heat Treatment: N/A

Plating/Finish: N/A

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 1/15/19

Signed: Henrietta Ralt

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
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